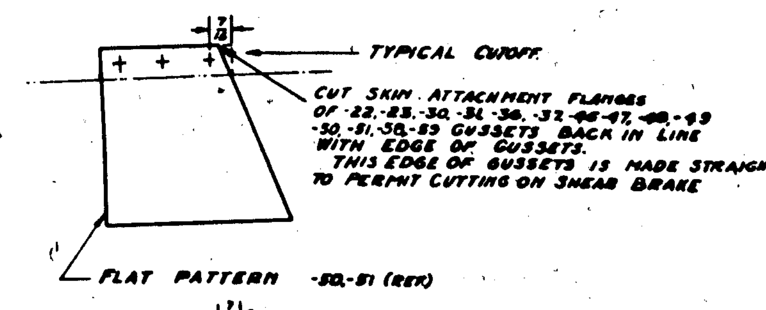
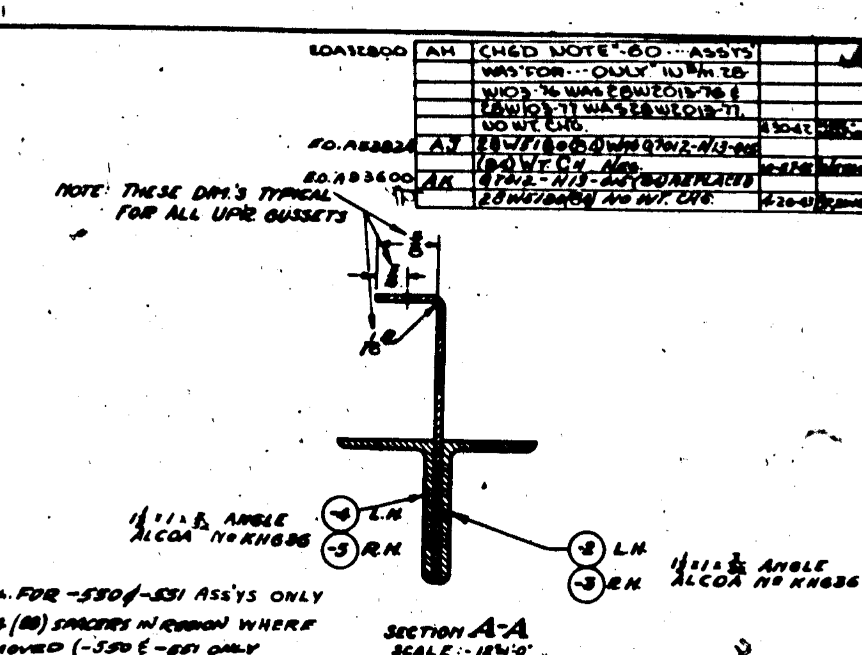
Q7012-H13-015 (REF)
AC224-3 (REF)
FLARE TUBE ENDS TO SECURE STUDS
ADD ZINC CHROMATE PASTE (#2)
NEOPRENE WASHER
28W5022-5 (REF)

TYPICAL BUTTON STUD INSTALL.





NOTE:
PARTS -36,-37,-54,-55,-57, COVERED BY CHANGE LETTERS, S, T, & TO BE HEAT TREATED TO NAVY SPEC. SR53

PBY-5 E.O. 28300

OMIT -54 TO 57 INCL. FOR -550 & -551 ASS'YS ONLY USE Q7006-D12-066 (80) SPACERS IN REGION WHERE -54 TO -57 ARE REMOVED (-550 & -551 ONLY)

NOTE:- TRIM GUSSETS TO CLEAR STRINGERS BY APPROX. 1/8

VIEW "A"

11 HOLES ON TOP FOR 28W5022-5 AC224-3 Q7012-H13-015 LOCATE HOLES AS PER WING TEMPLATES

Q61206-2 SPACER - USE AT ALL FLANGE RIVETS EXCEPT IN REGION OF GUSSETS

NOTE: -10 TO -21, INC. TO BE 1-1/4 x .050 EXTR. SEE ALCOA No K8047

Q61206-2 SPACER - USE AT ALL LOWER FLANGE RIVETS EXCEPT AT CLIPS AND GUSSETS

NOTE:- ATTACH -42,-43 TO BULKHEAD FLANGE WITH UPPER RIVET ONLY AT WING ASSEMBLY. SWING -42,-43 OVER TIGHT AGAINST STRINGER AND ADD LOWER RIVET (-42,-43 TO APPLY TO -0,-1 ASSY ONLY)

10 HOLES IN BOTTOM FOR 28W5022-5 AC224-3 Q7012-H13-015 LOCATE HOLES AS PER WING TEMPLATES

-60 & -61 EFFECTIVE ON -0 & -1 ASSYS ONLY. 28W105-76 & -77 TO REPLACE -60 & -61 ON 28W2103-550 & -551 ASSYS

-60 & -61 EFFECTIVE ON -0 & -1 ASSYS ONLY. 28W105-76 & -77 TO REPLACE -60 & -61 ON 28W2103-550 & 551 ASSYS

THESE ANGLE CLIPS TO BE ADDED AT WING ASSEMBLY

FOR -0,-1 ASSY ONLY

DETAIL OF -44 & -45
SCALE: 12"=1'0"

SECTION B-B
SCALE: 12"=1'0"

GENERAL NOTES:-
RIVETS TO BE AN442-D6 UNLESS OTHERWISE NOTED

FOR AIRFOIL ORDINATES SEE DWG. NO 28W101
USE AN442-D4 RIVETS AT -40-41-44 & -45
(R) ALL SHEET IS ALCLAD 24ST SPEC 47AB COND "T" EXCEPT AS NOTED ON -36, -37, -54, -55, -57.

FINISH CODE	
Z	ANODIC TREATMENT
P	P-27 PRIMER
GP	GREEN PRIMER
C	CADMIUM PLATE

H 505

ALL AL ALLOY EXTRUSIONS SPEC. 46A8 (COND. T) ALLOY 24-T EXCEPT AS NOTED. HEAT TREAT ALL COND. A MATERIAL PER SPEC SR53. RIVETS ALL AL. ALLOY EXCEPT AS NOTED

[redacted]

MATERIAL	NAVY NOTED
SPEC.	NOTED
HEAT TREAT	NOTED
FINISH	Z-P
	CONSOLIDATED AIRCRAFT CORP. BUFFALO, N.Y.
NAME	BULKHEAD-WING-STA. #3
DWG.	J 28W2103

R 28W2103